

REV: A	ENGINEERING DATA REQUIREMENTS (ATTACHMENT "A")	
NOTE: MILITARY SPECIFICATIONS /STANDARDS WILL NOT BE FURNISHED IN THE BID SET.		
1. THE FOLLOWING INSTRUCTIONS ARE FURNISHED FOR THE MANUFACTURE OF PISTON - SHOCK STRUT, MLG ASSY OF		
2. PART NUMBER 388059-11	3. NATIONAL STOCK NUMBER 1620-00-862-4057	
4. THE FOLLOWING SPECIFICATIONS/STANDARDS, ETC., WILL BE USED IN LIEU OF THE DATA INDICATED. THE SUPERSEDED DATA WILL NOT BE FURNISHED UNLESS SO INDICATED.		
<p>5. OO-ALC/LGHLEN SYSTEM ENGINEERING RETAINS ALL RIGHTS TO REVIEW AND ACCEPT/REJECT MRB'S PRIOR TO SHIPMENT OF DISCREPANT ITEMS. ALL DEVIATIONS, MINOR OR MAJOR, FROM THE ENGINEERING DRAWING PACKAGE WILL BE SUBMITTED FOR MRB DISPOSITION.</p> <p>6. PRIOR TO CONTRACT AWARD, THE CONTRACTOR WILL CERTIFY TO THE GOVERNMENT IN WRITING, FULL COMPLIANCE WITH MANUALS, SPECIFICATIONS, AND STANDARDS CALLED OUT AND REQUIRED FOR THE MANUFACTURE OF THIS CONTRACTED LANDING GEAR COMPONENT/ASSEMBLY. CONTRACTOR IS RESPONSIBLE TO COMPLETELY SEARCH THESE MANUALS, SPECIFICATIONS, AND STANDARDS AND FULLY UNDERSTAND THE REQUIREMENTS NECESSARY TO MANUFACTURE LANDING GEAR COMPONENTS. ANY QUESTIONS CAN BE FORWARDED TO THIS OFFICE OO-ALC/LGHLEN.</p> <p>7. IDENTIFICATION AND MARKING PER MIL-STD-130 IN LIEU OF LAC 0227.</p> <p>8. SERIAL NUMBER SHALL BE VIBROPEENED (WITH VIBRATING PNEUMATIC PENCIL), IN 0.09" LETTERS 0.004" - 0.007" DEEP IN THE LOCATION INDICATED. IF THE DRAWING DOES NOT INDICATE A LOCATION, OO-ALC/LGHLEN SHALL PROVIDE S/N LOCATION INSTRUCTIONS. SERIALIZATION OF ITEM SHALL BE ACCOMPLISHED AS FOLLOWS: THE SERIALIZATION SHALL BEGIN WITH THE CAGE OF THE CONTRACTOR NAMED ON THE CONTRACT, FOLLOWED BY A DASH AND THE 2 DIGIT YEAR OF MANUFACTURE, FOLLOWED BY A DASH AND A SEQUENTIALLY UNIQUE 3 DIGIT NUMBER. A CONTRACTOR WHO RECEIVES NUMEROUS INTERMITTENT CONTRACTS SHALL START SERIALIZATION OF ITEM WITH THE NEXT NUMBER IN SEQUENCE OF THE PRIOR CONTRACT. IF A CONTRACT PRODUCES MORE THAN 999 ITEMS, THE SERIAL NUMBER SHOULD BEGIN USING 4 DIGIT SERIAL NUMBERS. THE SERIAL NUMBER SHOULD APPEAR LIKE THIS: "S/N 98747-03-001".</p> <p>9. MATERIAL: 300M STEEL PER SAE AMS 6257 IN LIEU OF MIL-S-8844.</p> <p>10. CHROMIUM PLATE PER MIL-STD-1501, TYPE I OR II, CLASS 2, IN LIEU OF LAC 0496.</p> <p>11. TITANIUM CADMIUM PLATE AS NOTED PER MIL-STD-1500, CLASS 2, TYPE II IN LIEU OF STP 58-005.</p> <p>12. SHOT PEEN PER SAE AMS-S-13165, INTENSITY .008A - .012A, 200% COVERAGE.</p> <p>13. ROUGH FORGING (-991) TO BE NORMALIZED AND TEMPERED RHC 33 MAX. PER SAE AMS-H-6875 IN LIEU OF MIL-H-6875. FINISHED PART TO BE HEAT TREATED PER SAE AMS-H-6875 IN LIEU OF STP 54-006, MIL-H-6875 AND LAC PROCESS SPEC 522. PARTS HEAT TREATED TO 180 KSI AND ABOVE; ANY SURFACE GROUND/MACHINED AFTER HEAT TREAT SHALL BE INSPECTED FOR ABUSIVE GRINDING/MACHINING BURNS PER MIL-STD-867. GRINDING SHALL BE PER MIL-STD-866.</p> <p>14. FORGE AND INSPECT PER MIL-F-7190 IN LIEU OF LAC 0562 AND LAC PROCESS SPEC 562.</p> <p>15. REMOVAL OF FORGING DECARBURIZATION PER MIL-F-7190 IN LIEU OF LAC 0450.</p>		
PREPARED BY CAROL HYER	SYMBOL LGMPM	DATE 28 Jul 03

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<p>16. PERFORM MAGNETIC PARTICLE INSPECTION PER ASTM E 1444 IN LIEU OF STP53-001. USE FULL WAVE DIRECT CURRENT (FWDC), WET CONTINUOUS METHOD, FLUORESCENT TYPE WITH THE FOLLOWING ACCEPTANCE/REJECTION CRITERIA: NO DEFECTS ALLOWED. THE INTENT OF NO DEFECTS ALLOWED IS THAT THE INSPECTION IS CONDUCTED AT THE REQUIRED SENSITIVITY LEVEL AND THERE SHALL BE NO INDICATIONS ALLOWED. THE INSPECTOR PERFORMING THE INSPECTION SHALL BE CERTIFIED TO LEVEL II WITH THE INSPECTION PROCEDURE DEVELOPED BY A LEVEL III AS SPECIFIED IN AIA/NAS-410.</p> <p>17. FINISH TO MEET DRAWING SPECIFICATIONS PER THE FOLLOWING IN LIEU OF LAC 0471 AND LAC G-14. FOR FINISH 54-36-36 USE THE FOLLOWING:</p> <p>A. FOR 54, APPLY ONE COAT EPOXY WATERBORNE PRIMER PER MIL-PRF-85582, TYPE I, CLASS 2. ALTERNATE ONE COAT OF EPOXY POLYAMIDE PRIMER PER MIL-PRF-23377, TYPE I.</p> <p>B. FOR 36-36, APPLY TWO TOP COATS POLYURETHANE PER MIL-PRF-85285, TYPE I, COLOR NUMBER 17925 (WHITE) FED-STD-595.</p> <p>18. THREADS PER SAE AS8879, SAFETY CRITICAL.</p> <p>19. DWG 363174. 355000, 335111, DS5025 LAC REPORT NO. ER4741, LAC G-220 AND LAC PROCESS BULL G220 ARE NOT REQUIRED FOR MANUFACTURE.</p> <p>20. FIRST ARTICLE APPROVAL PER SAE AMS 2375 IN LIEU OF AMS 2375.</p> <p>21. FORGING REQUIREMENTS:</p> <p>A. THE FORGING SHALL BE PROCURED FROM THE ORIGINAL FORGING SOURCE, USING THE ORIGINAL CERTIFIED FORGING PROCEDURES AND DIES/TOOLING.</p> <p>1. PRIOR TO CONTRACT AWARD, THE DETAILED PART BIDDER SHALL PROVIDE CERTIFICATION, FROM THE FORGING SOURCE, TO THE GOVERNMENT THAT THE CERTIFIED DIES AND PROCEDURES ARE AVAILABLE AND THE FORGING SOURCE HAS AN AGREEMENT WITH THE DETAIL PARTS BIDDER TO PROVIDE FORGINGS FOR THEIR USE IN THE EVENT THEY ARE THE SUCCESSFUL BIDDER.</p> <p>2. PRIOR TO PRODUCTION, FORGING LOT QUALIFICATION SHALL BE ACCOMPLISHED AS SPECIFIED ON THE FORGING DRAWING AND SAE AMS-F-7190 FOR STEEL FORGINGS AND SAE AMS-A-22771 FOR ALUMINUM FORGINGS. THE DETAILED PART CONTRACTOR SHALL ASSURE THAT THIS HAS BEEN ACCOMPLISHED BY THE FORGING SOURCE AND SHALL SUBMIT CERTIFIED DOCUMENTATION OF ACCOMPLISHMENT TO THE GOVERNMENT.</p>		
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<p>B. FORGING SOURCE, CONTROL OF FORGING DIES AND THE LOCATION OF THE DIES:</p> <p>1. FORGING DRAWING: H388059-991</p> <p>DIE NUMBER: 4913P</p> <p>CONTROL OF FORGING PROCESS: HEROUX INC. (CAGE 36164) LONGUEIL, CANADA</p> <p>LOCATION OF FORGING DIES: KROPP FORGE COMPANY A DIVISION OF ANADITE, INC 5301 W. ROOSEVELT ROAD CICERO, IL 60804 PHONE: (709) 652-6691 POC: CHUCK MEYERS</p> <p>2. FORGING DRAWING: 546689-991</p> <p>DIE NUMBER: 6415</p> <p>CONTROL OF FORGING PROCESS: GOODRICH CO (CAGE 13002) CLEVELAND, OH 44105</p> <p>LOCATION OF FORGING DIES: CANTON DROP FORGE, INC 4575 SOUTHWAY STREET S.W. CANTON, OH 44706 PHONE: (330) 477-4511 POC: JOHN</p> <p>3. FORGING DRAWING: 3333895-991</p> <p>DIE NUMBER: 1286</p> <p>CONTROL OF FORGING PROCESS: HEROUX INC. (CAGE 36164) LONGUEIL, CANADA</p> <p>LOCATION OF FORGING DIES: INTERSTATE FORGING INDUSTRIES, SW DRIVE PO BOX 1030 INTERSTATE DRIVE NAVASOTA, TX 77868-1030 PHONE: (936) 825-7531</p> <p>THE PREFERRED CONFIGURATION FOR 388059 WILL BE MADE FROM 3333895-991 FORGING.</p>		
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